

Work Order ID 128181

Monday, January 12, 2015 10:36:50 AM

128181

Page 1

Item ID: D412-698-027

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket, Aluminum Door, LH

Start Date: 1/12/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/12/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MW

Date: 15-01-12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9484	C

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile &type labels per PPP D412-698-027/ DSI 9484
CHG003

DAS
27
9-89

FEB 25 2015

u 15-02-25

110 Pick Kit 0.00

110

Packaging

Packaging

Memo

0.00

u

15-02-25

DAS
28
9-89

FEB 25 2015

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Quality Control

Memo

0.00

[Signature]

DAS
27
9-89

FEB 25 2015

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Monday, January 12, 2015 10:36:50 AM

Item ID: D412-698-027

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket, Aluminum Door, LH

Start Date: 1/12/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/12/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-027/ DSI 9484

Location: FG 122

PPP rev: 1x Sold

2X

DAS
28
9-89

FEB 25 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS

1502-25

ME

15-2-25

Picklist Print

Monday, January 12, 2015 10:36:56 AM

Page 1

Work Order ID: 128181

128181

Parent Item: D412-698-027

D412-698-027

Parent Item Name: Bracket, Aluminum Door, LH

Start Date: 1/12/2015

Required Date: 1/12/2015

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 09.11.30 verified by:EC
11.03.31 AS PER ECN11-531 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3199-3		Manufactured	No			110	Each	9.0000	1	2			
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D3199-3

**

Bracket, Fwd LH

27
9-29

Location

ST026

77361

Loc Qty

9

9

Loc Code

2

28
9-29

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E OR LATER APPROVED REVISION
AND ICA-D412-698 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43
REF. FAA STC: SR01446NY
REF. EASA JM.R.S.00709

Field experience has shown that the forward D3199-1 brackets that are part of the D412-698-011/-012/-017 Cabin Door Roller Kits and forward D3675-1 brackets that are part of the D412-698-031/-032/-033 Cabin Door Roller Kits may wear prematurely if the aircraft is flown a significant amount of time with the sliding doors open. Dart has developed the D412-698-027/-028 kits that includes a longer D3199-3/-4 bracket for installation in the first forward position of the D412-698-011/-012/-017 kits to reduce wear on these forward brackets on aircraft equipped with aluminum doors. Likewise, Dart has developed the D412-698-037/-038 kits that includes a longer D3675-5/-6 bracket for installation in the first forward position of the D412-698-031/-032/-033 kits to reduce wear on these forward brackets on aircraft equipped with composite doors.

The D412-698-027/-028/-037/-038 kits may be installed as follows:

- 1) Remove the sliding door from the aircraft per Section 52.1 of ICA-D412-698
- 2) Remove the first forward D3199-1 or D3675-1 brackets as applicable.
- 3) Install the D3199-3/-4 or D3675-5/-6 bracket as applicable in lieu of the removed -1 bracket. Refer to Figure 1 Sheet 2 (aluminum doors) or Figure 2 Sheet 3 (composite doors).
- 4) Torque hardware per ICA-D412-698.
- 5) Re-install sliding door on aircraft per Section 52.2/52.3 of ICA-D412-698 as applicable.
- 6) Make entry in technical records of aircraft indicating that DSI 9484 has been completed.

PARTS LIST

QTY. -027	QTY. -028	QTY. -037	QTY. -038	PART NUMBER	DESCRIPTION
X				D412-698-027	BRACKET KIT, LH (ALUMINUM DOORS)
	X			D412-698-028	BRACKET KIT, RH (ALUMINUM DOORS)
		X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
			X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
1				D3199-3	FORWARD BRACKET, LH
	1			D3199-4	FORWARD BRACKET, RH
		1		D3675-5	FORWARD BRACKET, LH
			1	D3675-6	FORWARD BRACKET, RH

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal		Applicability
		Arm	Moment	Arm	Moment	
D412-698-027 Bracket Kit	0.16 lb 0.07 kg	-48.0 in -1.22 m	-7.68 in-lb -0.09 m-kG	102.3 in 2.60 m	16.37 in-lb 0.18 m-kG	Aircraft Equipped with P/N 205-032-669-XXX Aluminum Doors
D412-698-028 Bracket Kit	0.16 lbs 0.07 kg	+48.0 +1.22 m	+7.68 in-lb +0.09 m-kG	102.3 in 2.60 m	16.37 in-lb 0.18 m-kG	
D412-698-037 Bracket Kit	0.18 lb 0.08 kg	-48.0 in -1.22 m	-8.64 in-lb -0.10 m-kG	102.3 in 2.60 m	18.41 in-lb 0.21 m-kG	Aircraft Equipped with P/N 412-030-300-XXX Composite Doors
D412-698-038 Bracket Kit	0.18 lb 0.08 kg	+48.0 in +1.22 m	+8.64 in-lb +0.10 m-kG	102.3 in 2.60 m	18.41 in-lb 0.21 m-kG	

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE #02)

DATE: 11.03.21
CERT. NO.: SH92-43
ISSUE NO.: 5

C	UPDATED -027/-028/-037/-038 KITS AND INSTALLATION	MB	11.03.21
B	ADDED -037/-038 KIT FOR COMPOSITE DOORS; UPDATED TITLE ACCORDINGLY.	MB	10.12.17
A	NEW ISSUE	<i>[Signature]</i>	09.10.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9484	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	D412-698-027/-028/-037/-038 Kits	NTS
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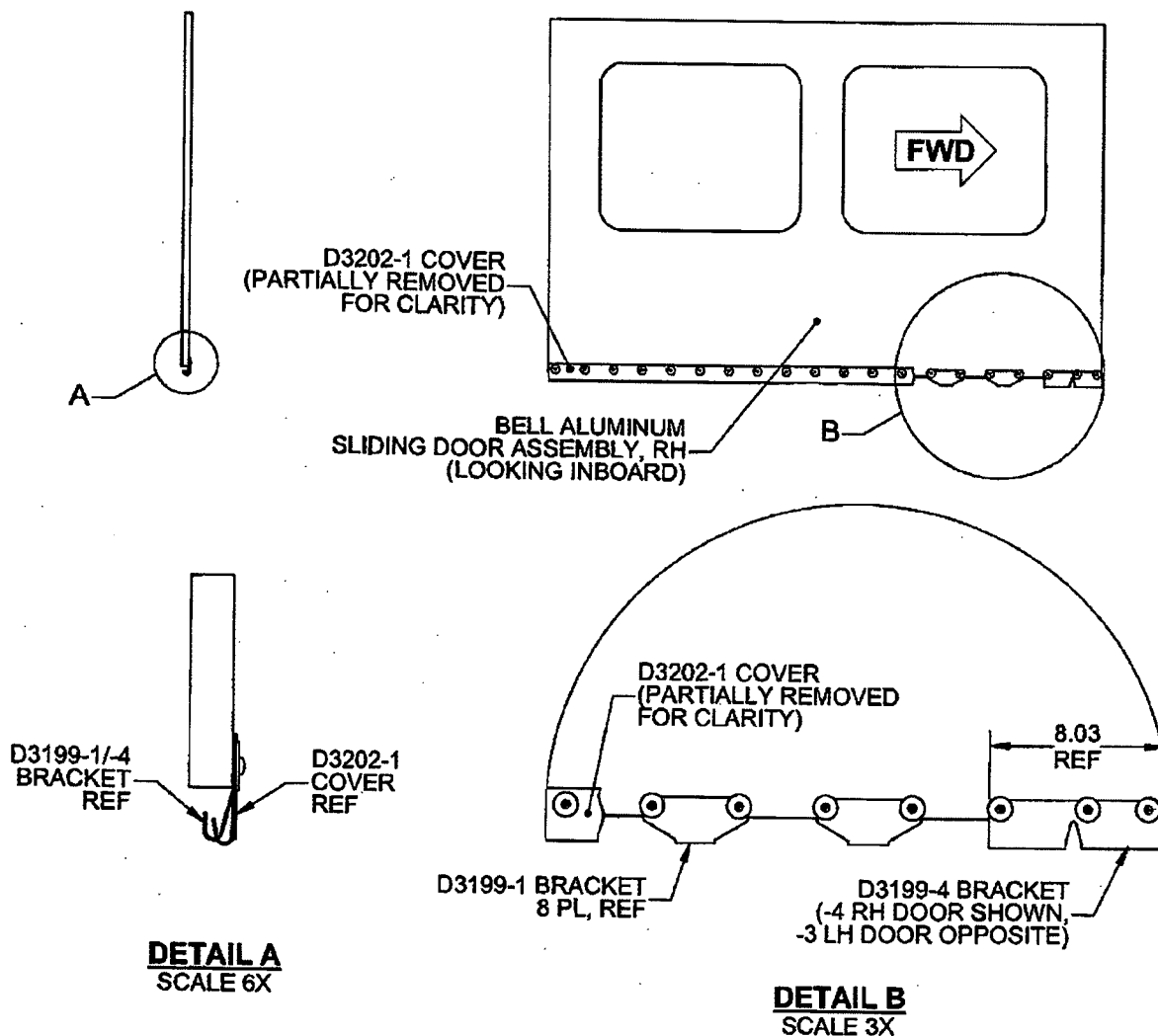


FIGURE 1: D3199-3/-4 BRACKET INSTALLATION ON ALUMINUM DOORS
(-4 SHOWN, -3 OPPOSITE)

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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D. SHEPHERD (DE # 02)

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MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE D412-698-027/-028/-037/-038 Kits	SCALE NTS
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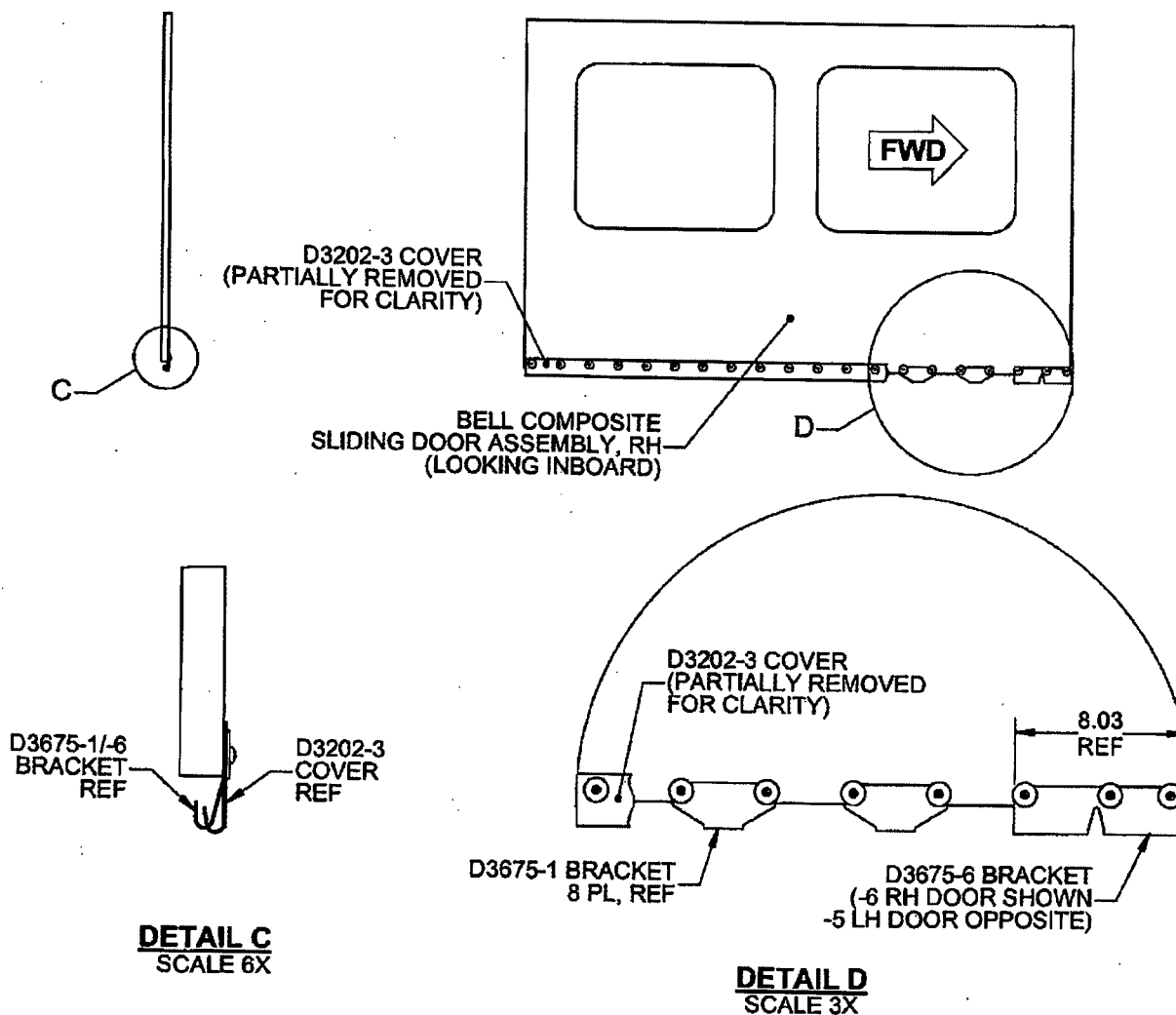


FIGURE 2: D3675-5/-6 BRACKET INSTALLATION ON COMPOSITE DOORS
(-6 SHOWN, -5 OPPOSITE)

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BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
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